

# Work Order ID 68672

Tuesday, April 19, 2011 3:57:41 PM

Page 1

Item ID: D2432

Accept

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 4/19/2011 Start Qty: 8.00

Required Date: 4/25/2011 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

B11-4-25

8

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio and Dwg D2432 Identify as D2432F  
3-Deburr

B.A 11/05/30

8

φ

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 11/05/30

8

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 68672**

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Page 2

Item ID: D2432

Accept

Revision ID:

Item Name: 206 (24") Bearpaw

Start Date: 4/19/2011 Start Qty: 8.00

Required Date: 4/25/2011 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

151

Identify as per dwg &amp; Stock Location: 69473

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/29  
MF  
11-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, April 19, 2011 3:57:48 PM

Page 1

Work Order ID: 68672

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw




Start Date: 4/19/2011

Required Date: 4/25/2011

Start Qty: 8.00

Required Qty: 8.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	227.0000	3.7	29.6			



1811-4-21

### Location

### Loc Qty

### Loc Code

MAT018

227

116554

2

117321

225

117321

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	68672
<b>Description:</b> Bearpaw		<b>Part Number:</b>	D2432
<b>Inspection Dwg:</b> D2432 <b>Rev:</b> F3		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.053 x 45°	✓		Vern	GA-01
B	5.500	+/-0.030	5.503	✓		"	"
C	0.200	+/-0.030	0.204	✓		D-6	GA-08
D	0.25 x 45°	+/-0.030	0.254 x 45°	✓		Vern	GA-01
E	R0.250	+/-0.030	R0.250	✓		R-6	ref.
F	0.250	+/-0.010	0.252	✓		Vern	GA-01
G	0.625	+/-0.030	0.629	✓		"	"
H	0.375	+/-0.010	0.378	✓		"	"
I	0.950	+0.030/0.010	0.958	✓		"	"
J	19.000	+/-0.030	19.000	✓		TAPE	GA-12
K	3.14	+/-0.030	3.160	✓		Vern	GA-01
L	3.28	+/-0.030	3.300	✓		"	"
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		"	"
N	Ø0.93	+/-0.030	Ø0.927	✓		"	"
O	0.30	+0.030/-0.000	0.312	✓		"	"
P	23.750	+/-0.030	23.750	✓		TAPE	GA-12
Q	7.375	+/-0.030	7.375	✓		Vern	CNC-02
R	4.250	+/-0.010	4.252	✓		Vern	GA-01
S	2.000	+/-0.030	1.995	✓		"	"
T	9.000	+/-0.010	9.000	✓		Vern	CNC-02
U	9.000	+/-0.010	9.000	✓		"	"
V	0.375	+/-0.010	0.380	✓		Vern	GA-01

<b>Measured by:</b> B.A	<b>Audited by:</b> <i>ML</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/05/30	<b>Date:</b> 11/05/31	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue      P/O K10008/D206-559-015	KJ/RF <i>RF</i>	<i>RF</i>

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

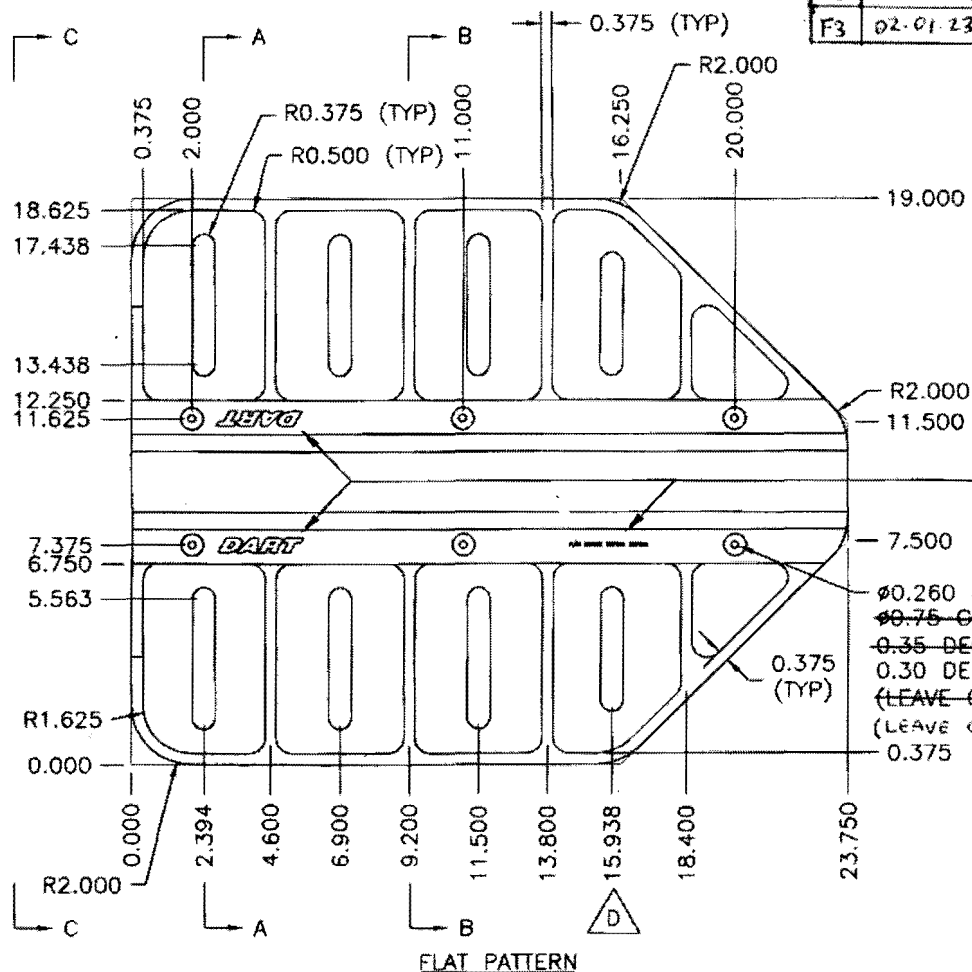
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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F1	99.03.03	ADD DEG 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 <del>RF</del>
F3	02.01.23	CLARIFY CORE DIMS <del>RF</del>



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

RELEASED  
93.06.17 KE

SHOP COPY  
RETURN TO

UNCONTROLLED COPY  
SUBJECT TO COMMENT  
WHICH NOTICE  
WILL BE ORDER  
NO. 11-04-19



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
MM	AS	D2432	
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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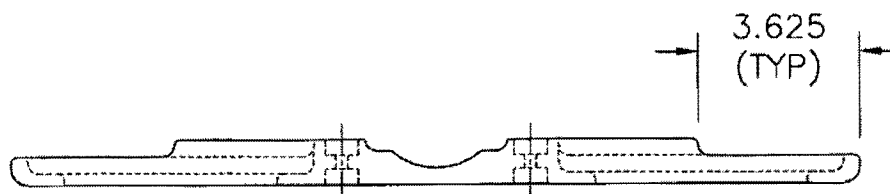
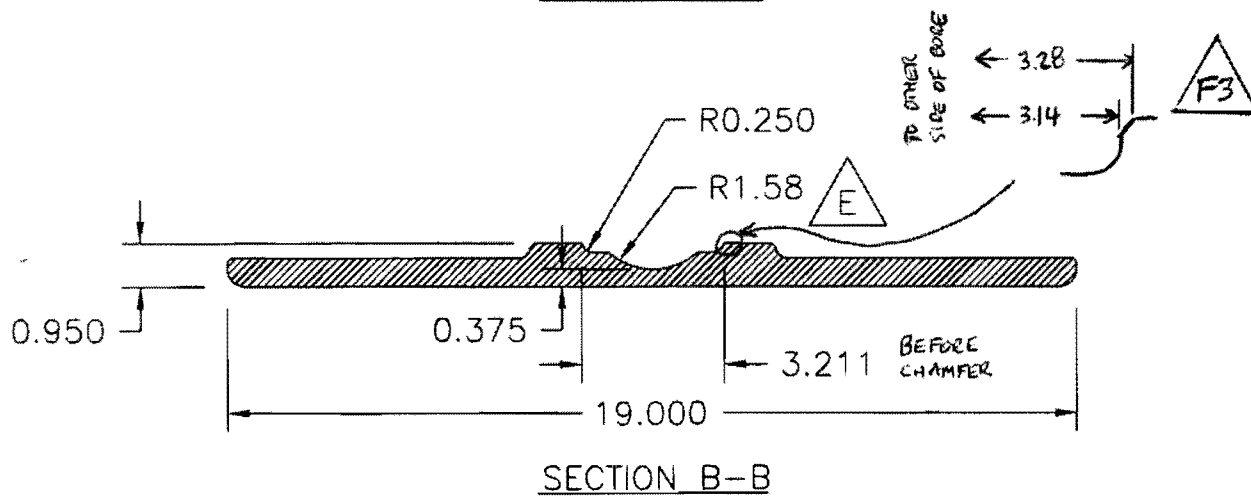
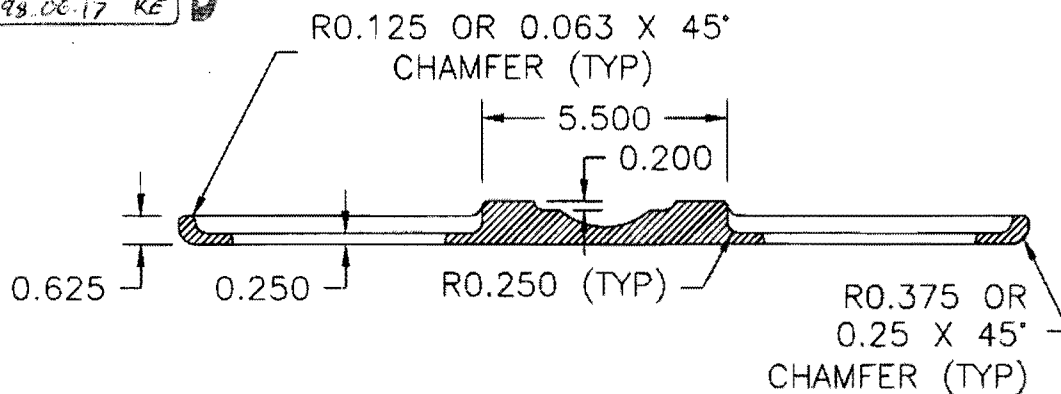
**NOTE:** Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

RELEASED  
98.06.17 KE

u/b 48672



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